Tuesday, 28/04/2009 12:38:17 PM User: Julie Dawson Customer : CU-DAR001 Dart Helicopters Services Job Number : 47563B : 10729 **Estimate Number** P.O. Number This Issue : 28/04/2009 Prsht Rev. : NC : // First Issue : 46324 **Previous Run** Written By Checked & Approved By Comment J/RF **Additional Product** Job Number: Seq. #: **Machine Or Operation:** 1.0 M304S16GA Comment: Qty.: 0.0184 sf(s)/Unit 304/316 .063 Sheet 2.0 WATER JET

Process Sheet

Drawing Name

: STRAP

Part Number

: D23245

Drawing Number

. D2324 REV C

Project Number

: N/A

Drawing Revision Material

: C

: 01/05/2009 **Due Date**

Qty:

40 Um: Each

: Est. E 03.02.28

Type

S.O. No. :

Reformat; Incorporated D2324-3 & D2324-5

: SMALL /MED FAB



Description:

304/316 Sheet .063

0.7360 sf(s)

B9-4-29

FLOW WATER JET



Comment: FLOW WATER JET 1-Cut as per Dwg D2324

> Dwg Rev:_ Prog Rev:

1B9-4-29

Total:

323

2-Deburr if necessary

QC2



189-4-29

Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2324-5T1

QC8 4.0

3.0

5.0



SECOND CHECK

Comment: SECOND CHECK



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

Page 1

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|---------|------|--------------------|----------------------|------------------------------|----------------|-------------------------------|--------------------------|-----------|--------------|--|--|--|
| W/O: | | WORK ORDER CHANGES | | | | | | | | | | |
| DATE | STEP | PRO | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | | | |
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| Part No | : | PAR #: | Fault Cate | gory: | _ NCR: Yes | No DQ | \ : | _ Date: _ | | | | |
| | Re | esolution: | Disposition | n: | _ QA: N/C Cld | sed: | | Date: _ | | | | |
| NCR: | | | WORK ORDE | ER NON-CONFORMA | NCE (NCR |) | | | - | | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | Verific | ation | Approval | Approval | | | |
| | 0.2. | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section | on C | Chief Eng | QC Inspector | | | |
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NOTE: Date & initial all entries

Date: User: Tuesday, 28/04/2009 12:38:18 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRAP

Job Number: 47563B

Part Number: D23245

Job Number:



Seq. #:

Machine Or Operation:

Comment: FINAL INSPECTION/W/O RELEASE

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





me 09-05-01

Job Completion



| W/O: | | WORK ORDER CH | WORK ORDER CHANGES | | | | | | |
|---------|------|------------------------|--------------------|--------------|-----|-------------------------------|--------------------------|--|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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| Part No | : | PAR #: Fault Category: | NCR: Yes | No DQ | A: | Date: | | | |

Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | |
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| | | Description of NC | | Corrective Action Section B | | Verification | Approval Chief Eng | T | | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | | Approval QC Inspecto | | | |
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| NOTE: D | ate & initial al | l entries | | | | | | <u> </u> | | | |

| DART AEROSPACE LTD | Work Order: リフィッスア |
|------------------------------|----------------------|
| Description: Strut | Part Number: D2324-5 |
| Description: Odd | Turchamoor. BLOZT |
| Inspection Dwg: D2324 Rev: C | Page 1 of 1 |

| Inspection Dwg | g: D2324 Rev : 0 | | | | | Pa | ge 1 of 1 |
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| | EIDST | ARTICLE IN | ISDECTIO | | CKLIST | | |
| | X | First Artic | | | otype | | |
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Со | mments |
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| Measured by: | iR . | Audited by: | | | Prototype Ap | proval: | N/A |
| Date: | 9-4-29 | Date: | 07/04/30 | | | Date: | N/A |
| Rev Date A 06.06.05 | Change New Issue | | | | | vised by | Approved |

| Rev | Date | Change | Revised by | Approxed |
|-----|----------|-----------|------------|----------|
| Α | 06.06.05 | New Issue | KJ/JLM 🗸 | |
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| W/O: | | | WO | RK ORDER CHAN | IGES | | | | | |
| DATE | STEP | PROCEDURE CHANGE | | | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Categ | ory: | NCR | : Yes N | lo DQ | A: | Date: _ | |
| | Res | solution: | Disposition | : | QA: | N/C Clo | sed: | | Date: _ | ··· |
| NCR: | | , | WORK ORDE | R NON-CONFORM | MANCE | (NCR) | | | | |
| DATE | STEP | Description of NC | | | ection B | | Verific | ation | Approval | Approval |
| | OIL! | Section A | Initial Chief Eng | Action Description Chief Eng | n | Sign & Date | Secti | | Chief Eng | QC Inspector |
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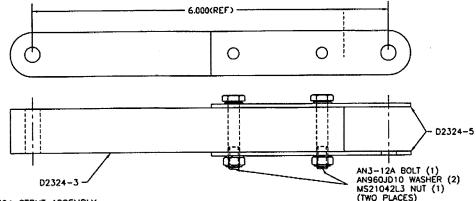
NOTE: Date & initial all entries



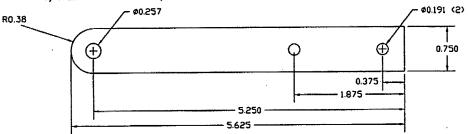
DESIGN DRAWN BY DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA **B WILLIAMS** PH REV. C CHECKED DRAWING NO. APPROVED D2324 SHEET 1 OF 1 TITLE SCALE DATE **STRUT** 04,12,14 **NEW ISSUE** 94.11.08 Α UPDATE MATERIALS В 96.05.07

RELEASED 04.12.16

UPDATE NOTES 04.12.14



D2324 STRUT ASSEMBLY 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324 - 3

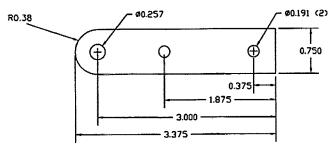
6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL:

(REF DART SPEC. M6061T6B0.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015 4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



02324 - 5

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE MORECORDER NO.,

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| W/O: | | | V | ORK ORDER CHANGE | S | | | | |
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| Part No |): | PAR #: | Fault Ca | tegory: | NCR: Yes | No DC |)A: | Date: _ | |
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| NCR: | | | WORK OR | DER NON-CONFORMAI | NCE (NC | R) | | | |
| DATE | CTED | Description of NC | | Corrective Action Section | n B | Verif | ication | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign Dat | & Sec | tion C | Chief Eng | QC Inspector |
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| | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | |
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NOTE: Date & initial all entries